

Work Order ID 151602

Monday, October 03, 2016 2:52:12 PM

151602

Page 1

Item ID: D350-748-243TRN

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Installation, High Aft

Start Date: 10/3/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 OCT 03 2016
QC: Date:

Tooling:

Date: Run Start ***NR1***SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D350-748-243	A
--------------	---

100

0.00

100

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

0.20

1-Cut tube on chop saw, leave extra mat'l for facing and install plugs 350-241 on both ends.

2-Face both sides of tube.

3- Turn program 02000 section on both side as per folio FB468.

4- Turn program 03000 section on both side as per folio FB468.

5- Blend transsition lines only with belt sander 60 grit

Folio rev: AADwg rev: 8

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

100 0.00 100 0.20 110 0.00

16/10/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	MORI SEIKI CNC LATHE LARGE	0.00				1	0		
120									
Mori Seiki	Memo	0.49							
Mori Seiki CNC Lathe Large	1- Turn program 04000 section on both side as per folio FB468.								
	2- Turn program 05000 section on both side as per folio FB468.								
	3- Blend transsition lines only with belt sander 60 grit								
	4-Scribe part # as per Dwg D350-748-243								
	Folio rev: <u>AA</u>								
	Dwg rev: <u>G</u>								
130	QC2- Inspect parts off machine FAI/FAIB	0.00				1	0		
130									
QC	Memo	0.00							
Quality Control	PERFORME ULTRASONIC MEASURMENT								

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

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Required Date: 10/10/2016 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

DAS
47
9-89

16-10-17

150

Large Fab

0.00

150

Crosstubes

Memo

0.20

Crosstubes

1-Grind machining marks

DPZ 16-10-24

190

Packaging

0.00

190

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack
Location: LG 14

DPZ 16-10-24

DQA: _____ Date: _____

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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
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Page 4

Item ID: D350-748-243TRN**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Crosstube Installation, High Aft**Start Date:** 10/3/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 10/10/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start *NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.20

Quality Control

16/10/24 [Signature]

16.10.24 [Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

Picklist Print

Monday, October 03, 2016 2:52:16 PM

Page 1

Work Order ID: 151602

151602

Parent Item: D350-748-243TRN

D350-748-243TRN

Parent Item Name: Crosstube Installation, High Aft

Start Date: 10/3/2016

Required Date: 10/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: PRELIM New Issue LL 12.05.08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6021-125		Manufactured	No				Each	41.0000		1			

D6021-125

Crosstube Material - 17-4Ph SS

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	25	
127271	25	
LG	16	
127272	16	

[Handwritten Signature]
10/10/16

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

DART AEROSPACE LTD		Work Order: 151602
Description: Crosstube Assembly (AS350/355 High Aft SS)		Part Number: D350-748-243
Inspection Dwg: D350-748-243 Rev: A		Page 1 of 2

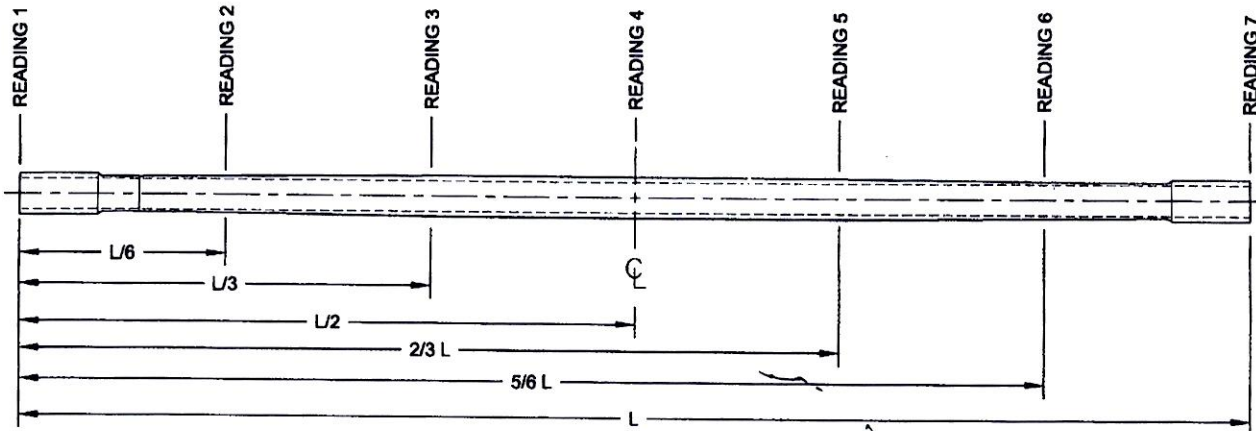
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+/-0.005	2.243	✓		↑	
	2.180	+0.005/-0.000	2.184	✓			
	2.180	+0.005/-0.000	2.183	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.237	✓			
	2.253	+0.005/-0.000	2.255	✓			
	2.272	+0.005/-0.000	2.277	✓			
	2.299	+0.005/-0.000	2.299	✓			
						Vernier	
	0.063	+/-0.010	0.063				
	5.25	+/-0.060					
	R0.063	+/-0.010	R0.063				
	R0.50	+/-0.030	R0.50				
SIDE B	2.240	+/-0.005	2.245	✓		↑	
	2.180	+0.005/-0.000	2.184	✓			
	2.180	+0.005/-0.000	2.183	✓			
	2.208	+0.005/-0.000	2.210	✓			
	2.234	+0.005/-0.000	2.237	✓			
	2.253	+0.005/-0.000	2.255	✓			
	2.272	+0.005/-0.000	2.272	✓			
	2.299	+0.005/-0.000	2.297	✓			
						Vernier	
	0.063	+/-0.010	0.063				
	5.25	+/-0.060	5.25				
	R0.063	+/-0.010	R0.063				
	R0.50	+/-0.030	R0.50				
	124.70	+/-0.060	124.70	✓		Vernier	

tape

DART AEROSPACE LTD		Work Order:	157602
Description: Crosstube Assembly (AS350/355 High Aft SS)		Part Number:	D350-748-243
Inspection Dwg: D350-748-243 Rev: A		Page 2 of 2	

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	125	125	124	125	0.001	0.030"
READING 2 L= 20.783	112	112	120	119	0.008	
READING 3 L= 41.567	153	151	150	154	0.004	
READING 4 L= 62.35	150	152	152	150	0.002	
READING 5 L= 83.133	153	150	150	153	0.003	
READING 6 L= 103.916	112	115	116	117	0.005	
READING 7 L= 124.699	128	127	123	125	0.005	

Calibration Result

Actual Block Thickness: 100-4520

Sitescan 250 Measured Thickness: 100-450

Measured by: <i>[Signature]</i>	Audited by: DAS 47	Preliminary Approval:	
Date: 2016/10/13	Date: 16-10-17	Date:	

Rev	Date	Change	Revised By	Approved
A	15.09.09	New Issue (P/O D350-748-203)	KJ	<i>[Signature]</i>

Item	Qty	Part Number	Description
	-243		
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20 OR MS21920-21/-22	CLAMP (PER DART SPEC. M-MS21920-20/-21/-22)
7	1	NAS1149C0363R	WASHER (OR AN960C10)
8	1	NAS1635-3-8	SCREW (OR MS51958-63)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.06 (AFTER BENDING/TRIMMING = 122.70 REF)
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.290 HOLE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- 10) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.

BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- 12) MAX AMPLITUDE OF RIPPLING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- 13) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

- 14) TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 151602 MJS
/60-03

DEO ATTACHED

RELEASED

2015 MAR 18 qf

RELEASED

2015 MAR 18 CK

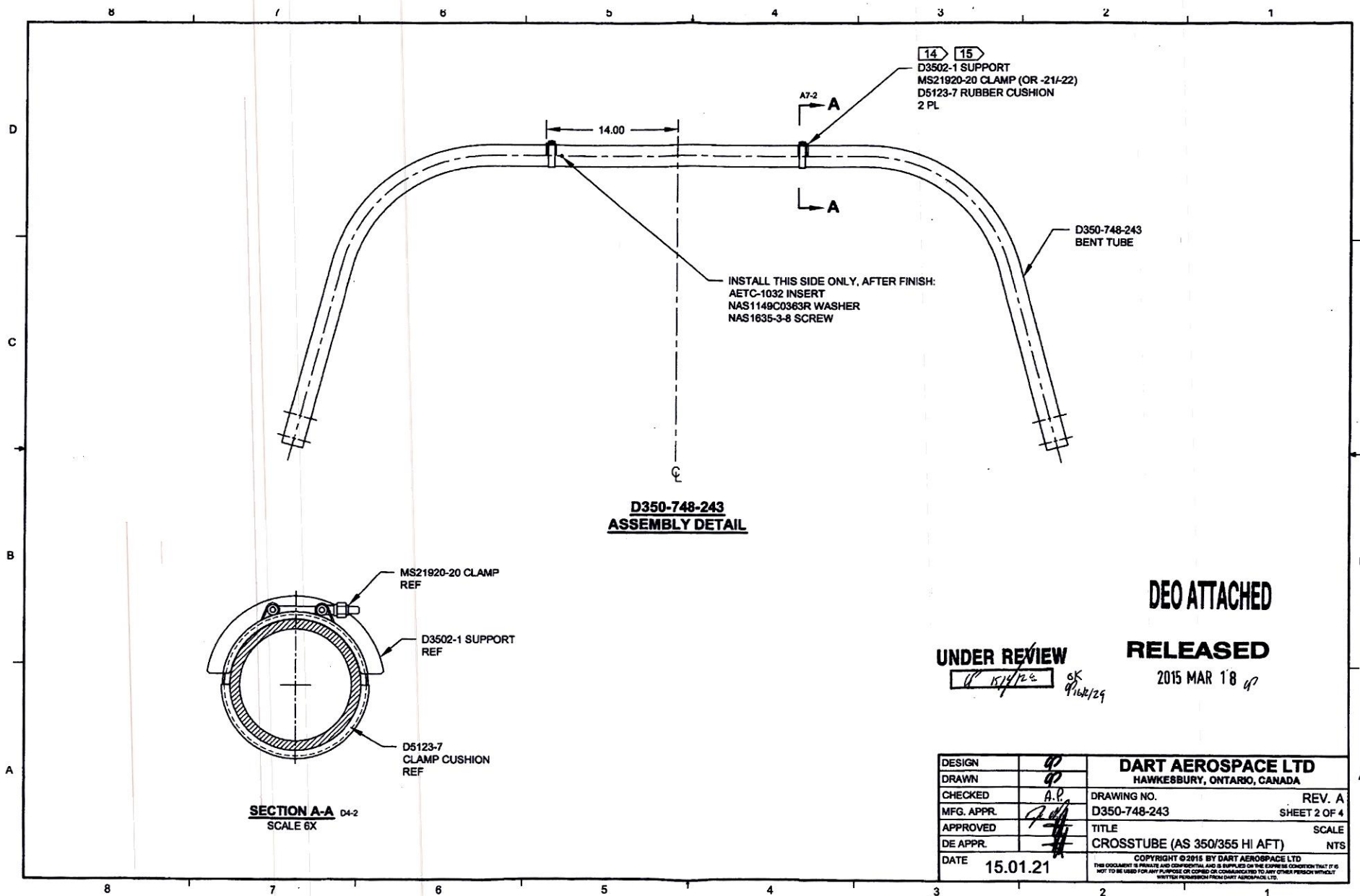
RCN 15/547 qf 14/2/25

UNDER REVIEW

15/4/25 CK
RF 15/541 qf 16/2/25

A	NEW ISSUE	CP	15.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	15.01.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-748-243	REV. A SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
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DEO ATTACHED

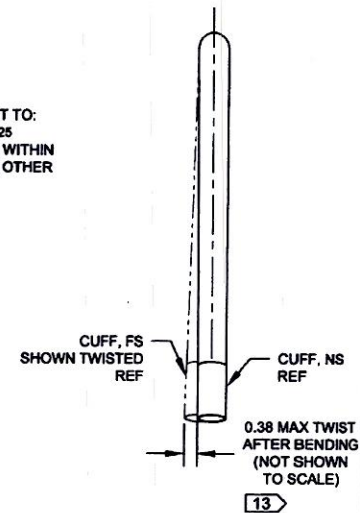
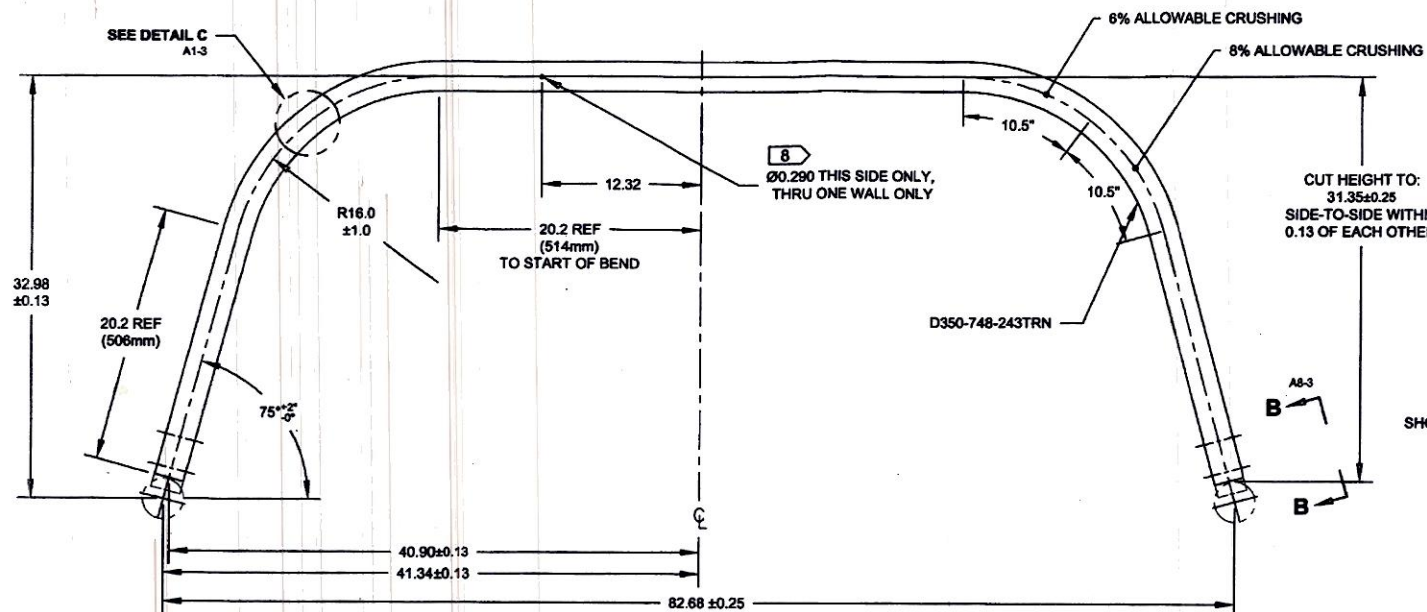
UNDER REVIEW

RELEASED

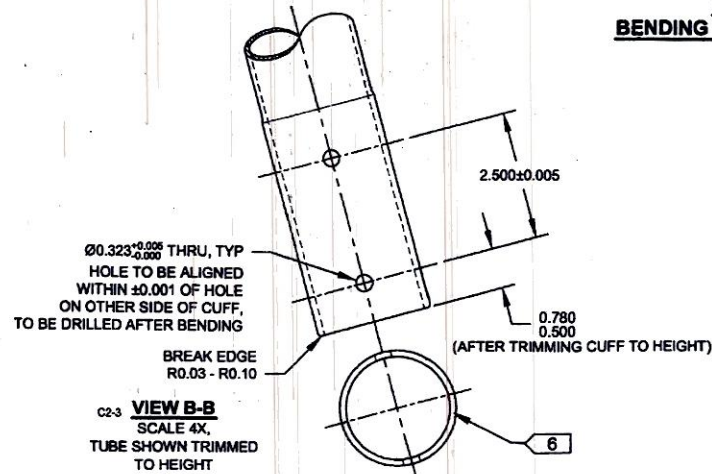
15/1/22 9/16/29

2015 MAR 18 47

DESIGN	40	DART AEROSPACE LTD	
DRAWN	40	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	7/1/22	D350-748-243	SHEET 2 OF 4
APPROVED	7/1/22	TITLE	SCALE
DE APPR.	7/1/22	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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D350-748-243
BENDING AND DRILLING DETAIL 11



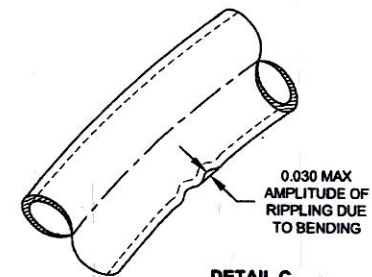
VIEW B-B
SCALE 4X,
TUBE SHOWN TRIMMED
TO HEIGHT

DEO ATTACHED
RELEASED

2015 MAR 18 *ap*

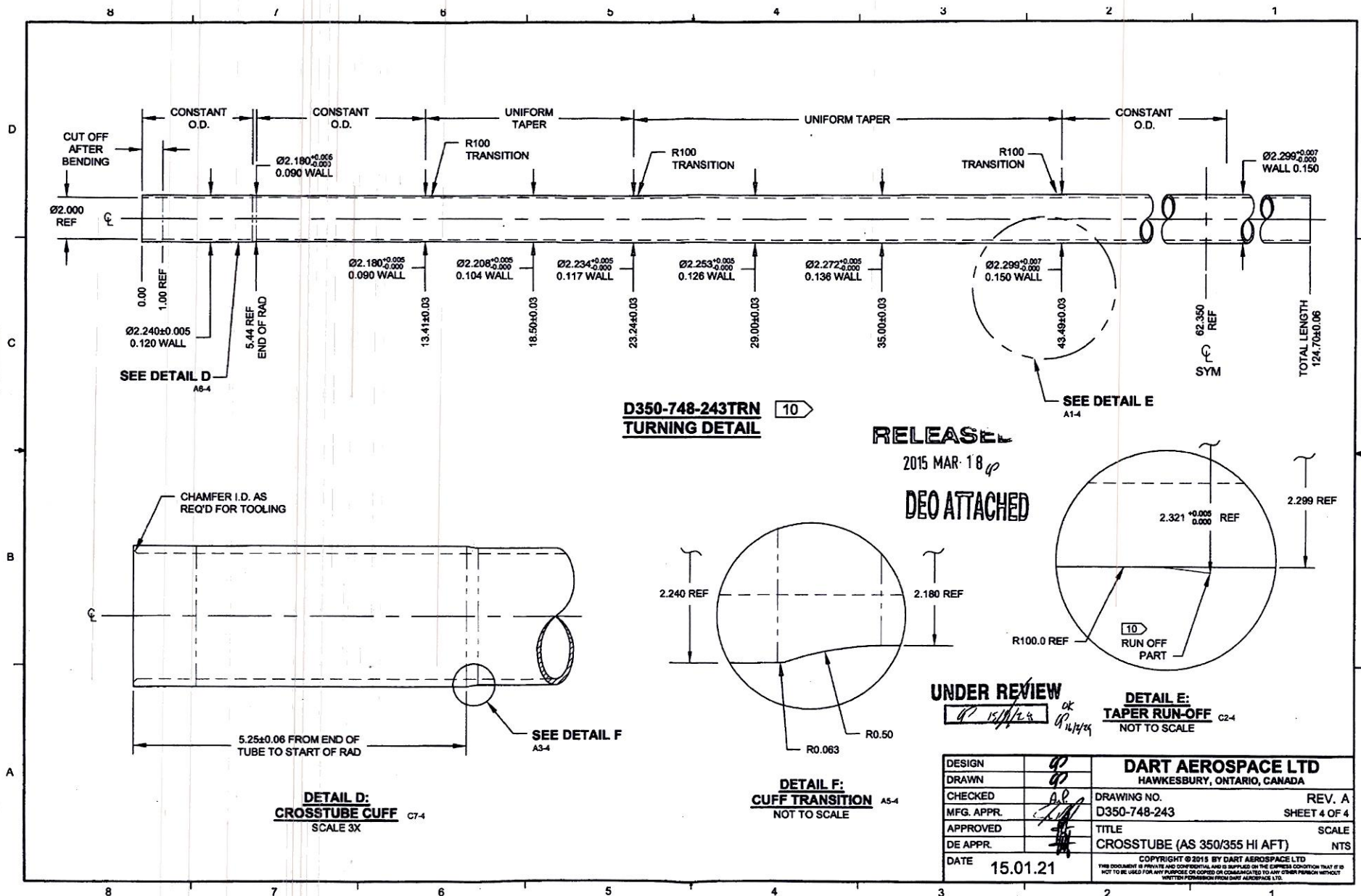
UNDER REVIEW

15/1/12 *OK* *9/12/15*



DETAIL C D7-3
SCALE 4X
RIPPLING EXAGGERATED

DESIGN	<i>ap</i>	DART AEROSPACE LTD	
DRAWN	<i>ap</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D350-748-243	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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D350-748-243TRN 10
TURNING DETAIL

RELEASED
 2015 MAR 18
 DEO ATTACHED

UNDER REVIEW
 15/1/14

DESIGN	OK	DART AEROSPACE LTD	
DRAWN	OK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	OK	DRAWING NO.	REV. A
MFG. APPR.	OK	D350-748-243	SHEET 4 OF 4
APPROVED	OK	TITLE	SCALE
DE APPR.	OK	CROSSTUBE (AS 350/355 HI AFT)	NTS
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DRAWING NO. D350-748-243	TITLE CROSSTUBE	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D350-748-243-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 15.11.18	DATE 15.11.18	DATE 16.02.19	DATE FEB 19 2016		DATE 2016.02.19		

AMEND NOTE 2 (SHEET 1) AS FOLLOWS:

- 2) FINISH: PREPARE SURFACE PER DART QSI 005 4.1.4
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
 OR
 POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

RELEASED
 2016 -02- 26
EN 16-534

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